

Date: Tuesday, 8/21/2007 3:43:26 PM  
 User: Kim Johnston

## Process Sheet

|                                                        |                                        |
|--------------------------------------------------------|----------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services         | Drawing Name : TUBE                    |
| Job Number : 34182                                     |                                        |
| Estimate Number : 11175                                |                                        |
| P.O. Number : <i>N/A</i>                               | Part Number : D22825                   |
| This Issue : 8/21/2007 S.O. No. : <i>N/A</i>           | Drawing Number : D2282 REV E           |
| Prsht Rev. : NC                                        | Project Number : <i>N/A</i>            |
| First Issue : <i>N/A</i> Type : MACHINED PARTS         | Drawing Revision : E                   |
| Previous Run : 33416                                   | Material : <i>N/A</i>                  |
| Written By : <i>[Signature]</i>                        | Due Date : 9/20/2007 Qty: 100 Um: Each |
| Checked & Approved By : <i>[Signature] 07.08.22</i>    |                                        |
| Comment : Est Rev: A Removed from 9 Digit 05-12-02 JLM |                                        |

Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |           |
|-----|-----------|-----------|
| 1.0 | M304R0750 | Inventory |
|-----|-----------|-----------|



Comment: Qty.: 0.1891 f(s)/Unit Total: 18.9063 f(s)

Material: AISI 304 Stainless Steel Ø0.750(M304R0.750)

Batch *1164534 # DTP 07/09/21 M102085 29 07/09/22-23*

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

*DTP 07/09/21 29 07/09/22-23*

|     |     |                                        |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DTP 07/09/21 29 07/09/22-23*

|     |               |                              |
|-----|---------------|------------------------------|
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

Mill Arc as per Dwg D2282

*gm/SL 07/09/26*

|     |     |                                        |
|-----|-----|----------------------------------------|
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*gm/SL 07/09/26*

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 34182

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/27

(110)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/9/27

SP

(110x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/28

Job Completion



U 07-09-28

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

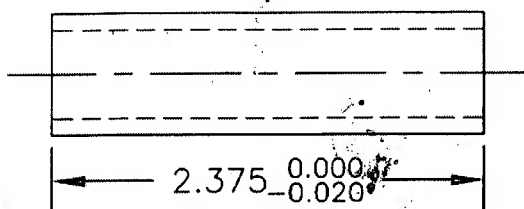




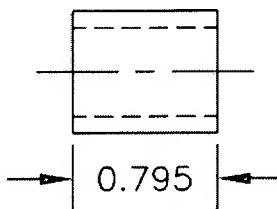
|                               |                                |                                                                 |                        |
|-------------------------------|--------------------------------|-----------------------------------------------------------------|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                                            | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07              | TITLE<br>HANDLE TUBES          |                                                                 | SCALE<br>1:1           |
| A                             | 94.10.14                       | NEW ISSUE                                                       |                        |
| B                             | 95.03.23                       | RE-DESIGN                                                       |                        |
| C                             | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                             | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                             | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

RELEASED  
*[Signature]*

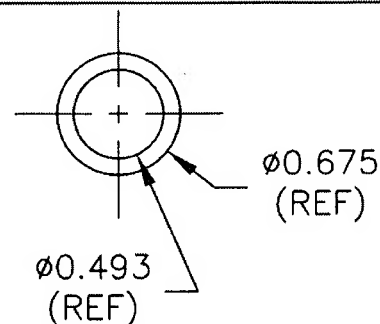
05/09/16



**D2282-3**

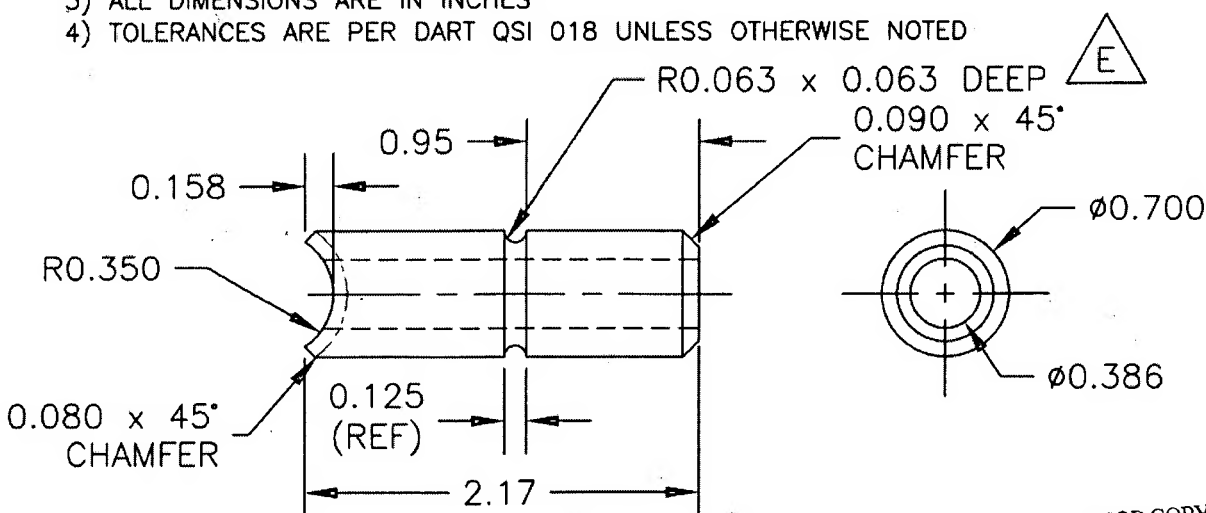


**D2282-7**



**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2282-5**

**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

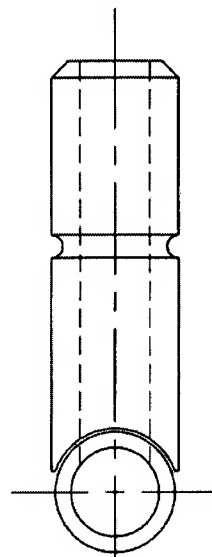
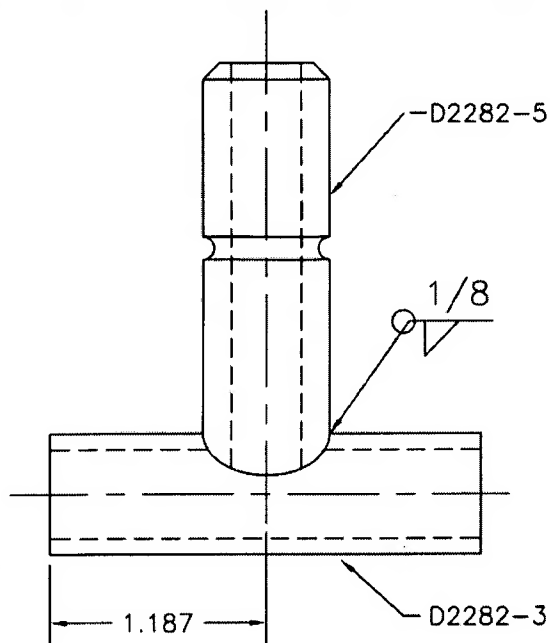
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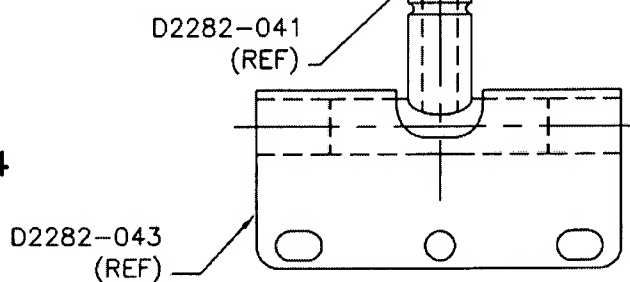


|                      |                                |                                                   |                        |
|----------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW         | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>UP</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07     | TITLE<br>HANDLE TUBES          |                                                   | SCALE<br>1:1           |

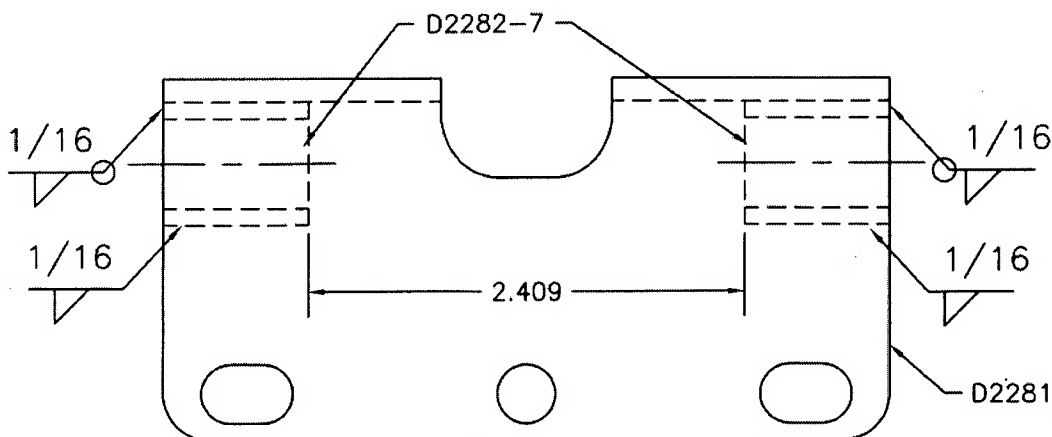


RELEASED  
*[Signature]*  
05/09/16

**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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